

Work Order ID 83104

83104

Page 1

Thursday, April 12, 2012 4:01:47 PM

Item ID: D3937-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Luminescent Strip Assembly

31

Start Date: 4/12/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 4/26/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: *P*

Date: 12-04-12 Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3937	B

100

100

Shear

Shear

0.00

16 *P* 12-05-07

Memo

1-Cut as per Dwg D3937 (Make D3937-3)
Dwg Rev: *B*

2-Deburr if necessary

110

110

QC

Quality Control

0:00

QC2- Inspect parts off machine FAI/FAIB

Memo

120

120

QC

Quality Control

0:00

QC8- Inspect parts - second check

Memo

0.00

5076000

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83104***83104***

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Thursday, April 12, 2012 4:01:47 PM

Item ID: D3937-041 Accept: *N900040100* Setup Start: *NS1*

Revision ID:

Item Name: Luminescent Strip Assembly

Start Date: 4/12/2012 Start Qty: 16.00 *16*

Required Date: 4/26/2012 Req'd Qty: 16.00 *16*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start: *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop: *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Hand Finishing

(16) 261258

140 QC3- Inspect Part Finish

0.00

140

QC

Quality Control

16✓ d 4/10/08

150 0.00

150

Small Fab

Small Fab

Memo

0.00

1- Align part edges and stick strip to D3937-3 as per dwg

31 FF 13-04-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 83104

83104

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Thursday, April 12, 2012 4:01:47 PM

Item ID: D3937-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Luminescent Strip Assembly

Start Date: 4/12/2012 **Start Qty:** 16.00

16

Cust Item ID:

Required Date: 4/26/2012 **Req'd Qty:** 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

160

QC5- Inspect part completeness to step on W/O

0.00

DAS

21

B430

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

160

QC

Quality Control

170

Identify as per dwg & Stock Location: *55074* 0.00

0.00

31x

Can

31x

*SO
13-430.*

170

Packaging

Packaging

180

QC21- Final Inspection - Work Order Release 0.00

0.00

13/05/030

180

QC

Quality Control

13/01/30

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, April 12, 2012 4:01:52 PM

Work Order ID: 83104

83104

Parent Item: D3937-041

D3937-041

Parent Item Name: Luminescent Strip Assembly

Start Date: 4/12/2012

Required Date: 4/26/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3937-1		Manufactured	No				Each	20.0000		16			

D3937-1

Luminescent Strip

Location	Loc Qty	Loc Code
ST072	17	B 94531
77627	17	
ST094	3	
73537	3	

M6061T6S.032

Purchased

No

100 sf 304.1560 0.09099 1.532463

M6061T6S 032

6061-T6 Sheet 0.032"

**

(16)

FF
12-05-07

Location	Loc Qty	Loc Code
MAT021	304.156	
118106	48.606	
120218	33.77	
120285	43.68	
121099	178.1	

1.532463

S 13/04/29

B 89647

D3937-3

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

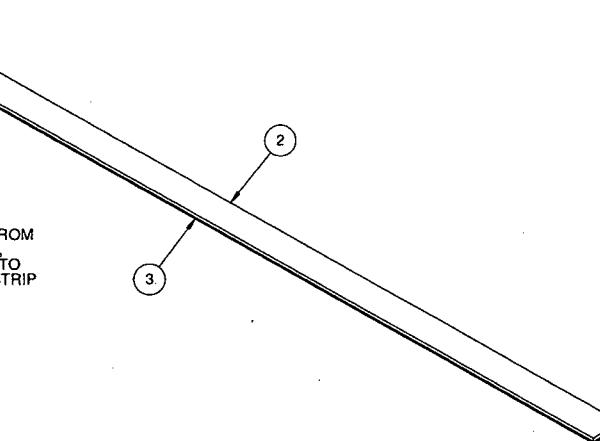
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3937-041	LUMINESCENT STRIP ASSEMBLY
2	1	D3937-1	LUMINESCENT STRIP
3	1	D3937-3	SHEET METAL BACKING STRIP

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 83104
PL12-04-12

PEEL SELF-ADHESIVE BACKING FROM
 D3937-1 LUMINESCENT STRIP,
 ALIGN PART EDGES AND STICK TO
 D3937-3 SHEET METAL BACKING STRIP



D3937-041 LUMINESCENT STRIP ASSEMBLY

RELEASED
 2009-12-02
MP

B	SHEET 2 SPEC CHART LENGTH WAS 21.0. SHEET 3 ZONE C5 19.5 DIM WAS 21.0. REASON: PREVENT EXCESSIVE WASTE.		AJS	09.11.27
A	NEW ISSUE		<i>E</i>	09.06.02
REV.	DESCRIPTION	BY	DATE	
DESIGN	<i>E</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AUS	DRAWING NO.	D3937	REV. B SHEET 1 OF 3
CHECKED		MFG. APPR.		
APPROVED		DE APPR.		TITLE LUMINESCENT STRIP NTS SCALE
DATE	09.11.27			COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE WHATSOEVER OTHER THAN WITHIN THE WRITTEN PERMISSION FROM DART AEROSPACE LTD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3937-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

W/O:		WORK ORDER CHANGES					
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8

7

6

5

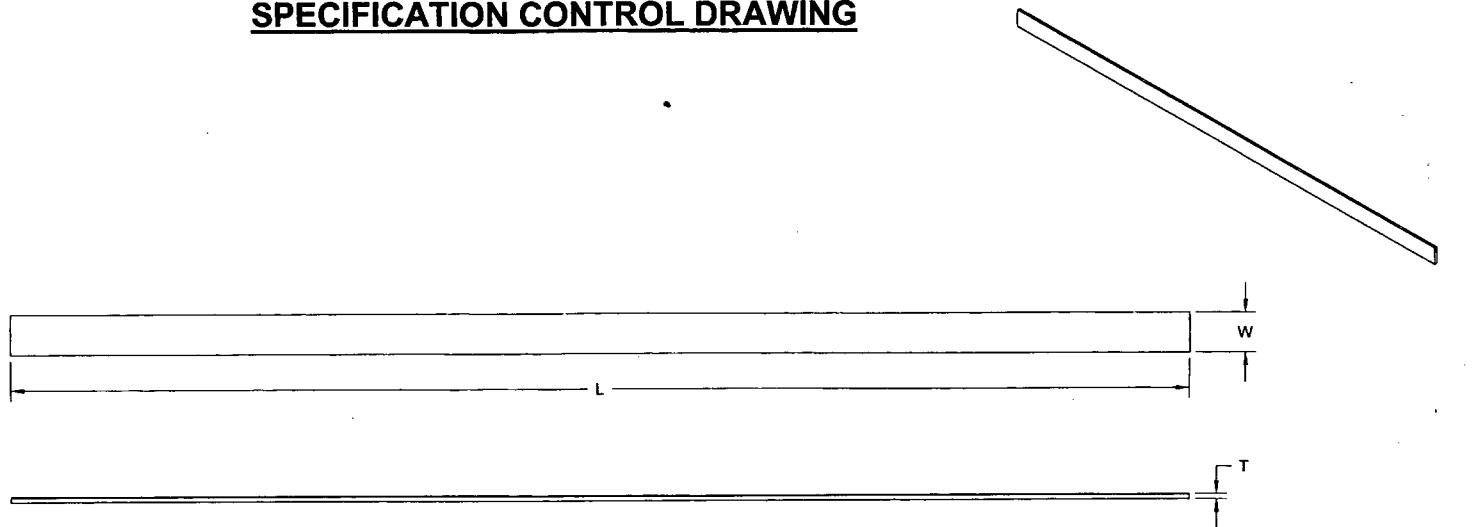
4

3

2

1

SPECIFICATION CONTROL DRAWING



D3937-1 LUMINESCENT STRIP

83104

DART PART NUMBER	LENGTH "L"	WIDTH "W"	THICKNESS "T"	SUPPLIER	SUPPLIER PART NUMBER	WEIGHT
D3937-1	19.5	0.67	0.09	LUFTHANSA TECHNIK	PL88-990LH00	0.04 LBS

▲

RELEASED
2009-12-02
MM

NOTES:
 1) MATERIAL: SEE TABLE
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: SEE TABLE

8

7

6

5

4

3

2

1

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	AJS	HAWKSLEY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. B
MFG. APPR.	<i>[Signature]</i>	D3937 SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	LUMINESCENT STRIP NTS
DATE	09.11.27	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY INFORMATION OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

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7

6

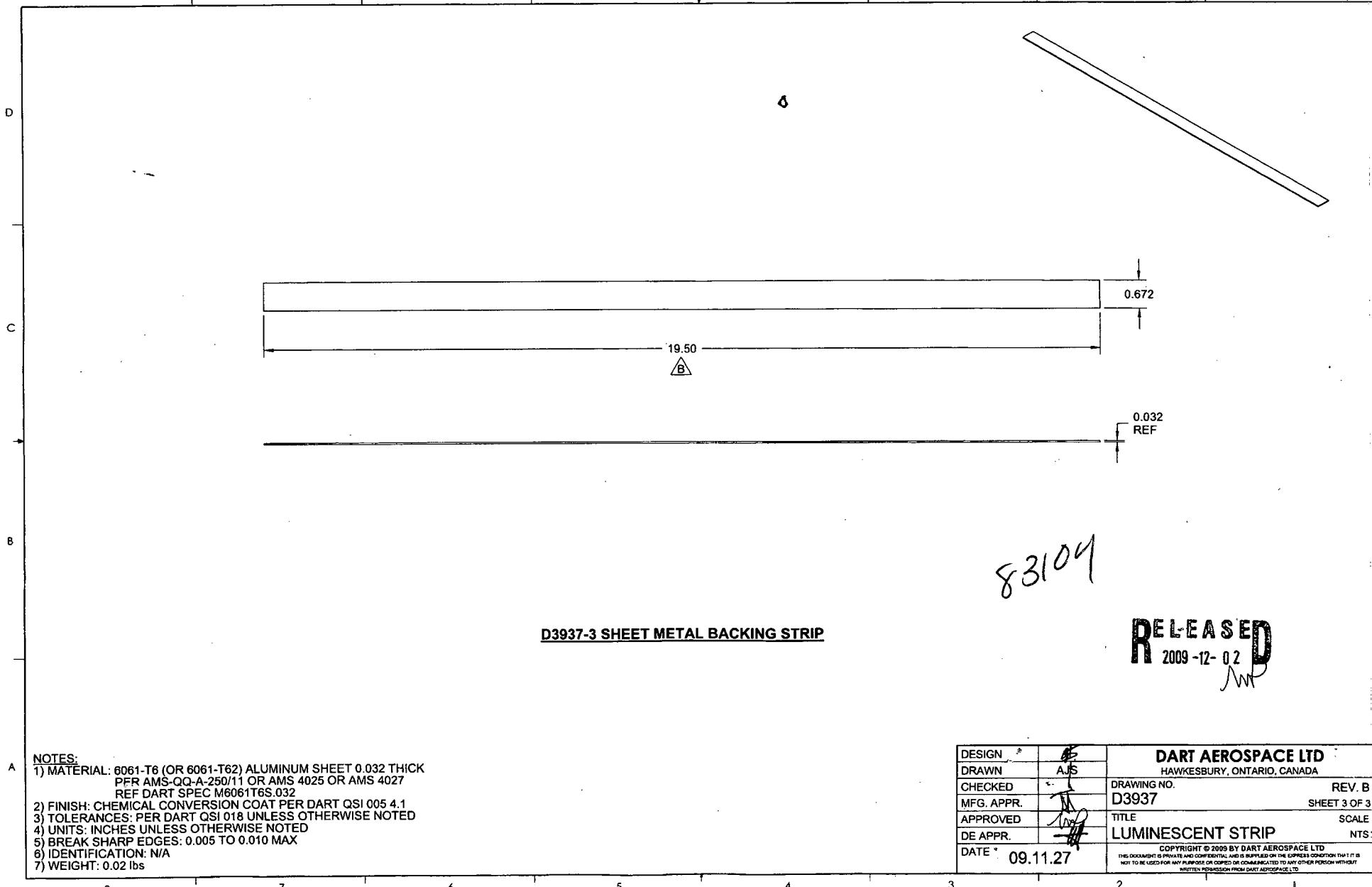
5

4

3

2

1



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